

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008195**Date Inspected:** 31-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Guo Peng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower components**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Dilip Chakrabarti was present during the times noted above for observations relative to the work being performed.

Bay# 10- Tower Assembly:

This QA Inspector randomly observed the following work in progress:

**SMAW Process:**

Welding of weld joint# 66A located on PCMK NSD1 FESA4-1 E/E. Welder is identified as 040269. ZPMC QC is identified as Chen Deng Zhi Bing. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3211-TC-U5b-1.

Welding of weld joint# 66A located on PCMK NSD1 FESA4-1 E/E. Welder is identified as 040269. ZPMC QC is identified as Chen Deng Zhi Bing. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3311-TC-P5.

Bay# 11- Tower Assembly:

This QA Inspector randomly observed the following work in progress:

**FCAW Process:**

Welding of weld joint# 5 located on PCMK WSD1 FDSA4-4 D/D. Welder is identified as 069043. ZPMC QC is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the specified WPS no.

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

B-T-2332-TC-P5-F.

Welding of weld joint# 6 located on PCMK WSD1 FDSA4-4 D/D. Welder is identified as 070046. ZPMC QC is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P5-F.

Welding of weld joint# 47 located on PCMK WSD1 FDSA4-4 D/D. Welder is identified as 067184. ZPMC QC is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P5-F.

Welding of weld joint# 48 located on PCMK WSD1 FDSA4-4 D/D. Welder is identified as 066865. ZPMC QC is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2332-TC-P5-F.

### Magnetic Particle Testing (MT):

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report on this date. The member and the weld designations are as follows:

Sl # Section # Weld # Green Tag # Location

1. WD1- A6001-6 3 A NA NA
2. WD1- A6001-3 1B NA NA
3. WD1- A6001-7 2 A NA NA
4. WD1- A6001-7 4 A NA NA
5. WD1- A6001-7 5 A NA NA
6. WD1- A6001-7 6 A NA NA
7. WD1- A6001-8 2 A NA NA
8. WD1- A6001-8 5 A NA NA
9. WD1- A6001-8 3 A NA NA
10. WD1- A6001-6 1 A NA NA
11. WD1- A6001-6 2 A NA NA
12. SD1 A6002-13 3B NA NA

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

13. SD1 A6002-14 1A NA NA

14. SD1 A6002-15 3A NA NA

15. SD1 A6002-15 1B NA NA

Unless otherwise noted, all work observed on this date appeared to be generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversation

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Chakrabarti,Dilip Kumar	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

---